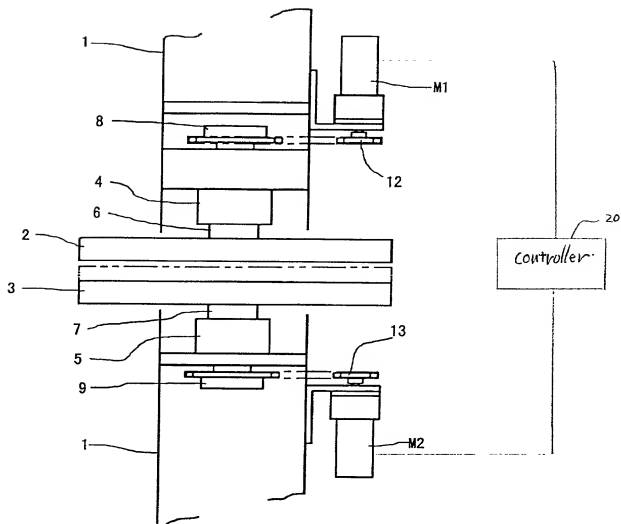
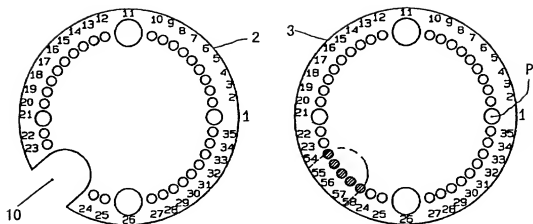


Fig. 1



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Fig. 2A



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Fig. 2B

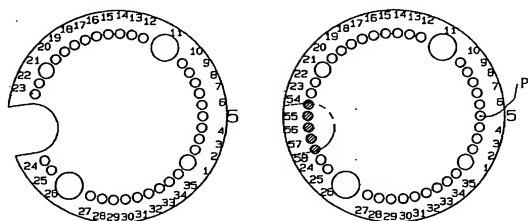
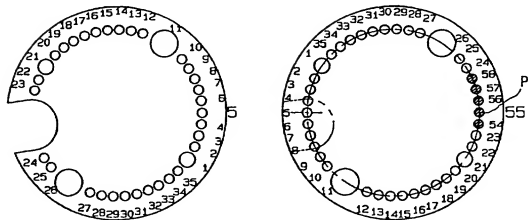


Fig. 2C



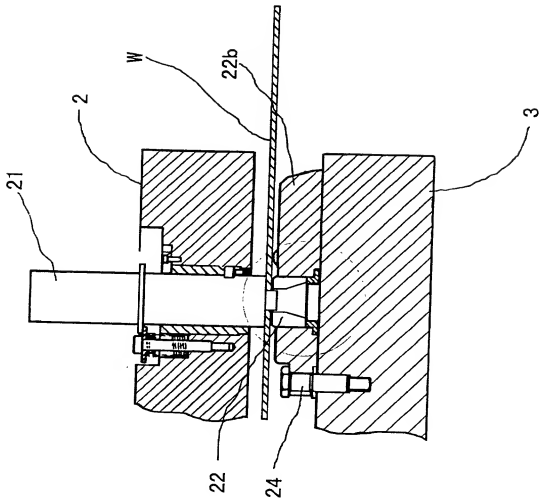
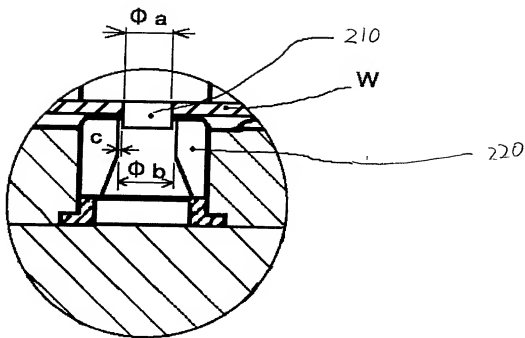


Fig. 4



$\Phi a$  : Diameter of blade of upper mold 210

$\Phi b$  : Diameter of hole of lower mold 220

$c$  :  $(\Phi b - \Phi a) / 2$  (Clearance. )

Fig. 5.

